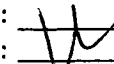
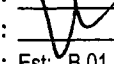


Date: Thursday, 10/08/2006 10:02:17 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ASPIRATOR
<b>Job Number</b> : 28138	
<b>Estimate Number</b> : 11968	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2061
<b>This Issue</b> : 10/08/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2061 REV. A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 05/09/2006 <b>Qty:</b> 25 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est: B 01.12.17 Added step.3, 4 and Inspection Level 21. SM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASING

Issue P/O: 1809

Make per Dwg D2061

Possible Supplier: Sieg's Manufacturing

Material release note required

C206108110

(25)

2.0	D2061P	Aspirator
-----	--------	-----------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 25.0000 Each(s)  
 ASPIRATOR BODY

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

PU 6/9/01 (25)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK

C20610815 25

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr and clean to remove was residue

FF 06.09.20 25

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *Q*   Date:   06/09/20    
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 10/08/2006 10:02:17 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 28138

Part Number: D2061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

06/09/20

25

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

SB

06/09/20

55

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB

06/09/20

(25)

Job Completion



U

06/09/20

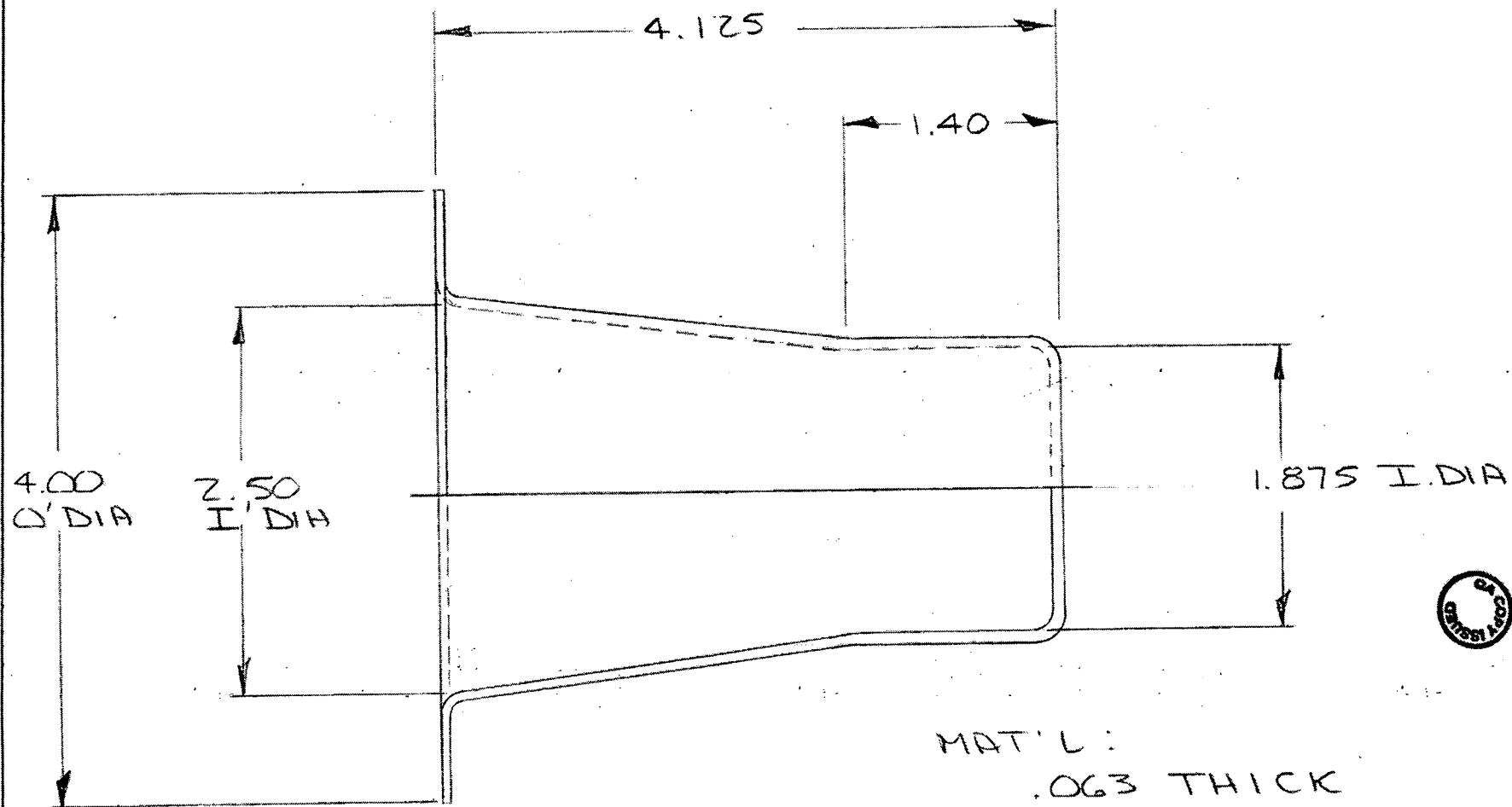
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



MAT'L:  
 .063 THICK  
 1100 ALUMINUM

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPOD OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 623	PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN			BASIC CODE	DIA. DASH NO.	CONTRACT NO.	DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED			D=CHAMFER O=DRILLING OF SHEETS C=COUNTERSINK	W=SPOTWELD	DRAWN BRADLEY	DATE JAN 24 1992		
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		TITLE ASPIRATOR BODY			
	GENERAL		LIMITS		CODE			
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125+ 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH . S. 7742 5. HOLES PER AND 10387		1. TOLERANCES — .001 & .002 2. ANGLES .001 & .010 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		DWG NO. YSD ZOG 1			
REPORT ALL DISCREPANCIES — DO NOT SCALE								

YSD 2061

A



Sieg's Manufacturing Ltd.

604 530-7455 fax 604 530-7490

6236-205 Street, Langley, British Columbia, Canada. V2Y 1N7

## INSPECTION REPORT

DATE: Aug. 25/06

CUSTOMER: Dart Aerospace

INVOICE #: \_\_\_\_\_ SUPPLIER #: \_\_\_\_\_

DESCRIPTION OF INSPECTION: \_\_\_\_\_

PART #	QTY.	MATERIAL	CHECK HOLES	DEBUR EDGES	INSP BY.
D2061P	25	.063 1100 ✓	N/A	✓	Kale

NOTES OF INSPECTION: Good.

NOTES OF REJECT: \_\_\_\_\_



# Certification of Test Results

**SOLD TO:**  
KEN-MAC METALS INC  
2 THYSSEN DRIVE  
DETROIT, MI 48210

**TO BE ADVISED**  
PA

**OLD**

PO 811326

**CERT NO** 0000043817  
**DATE** 7/01/1998  
**SKID NO** 631706  
**SKID WGT** 9,560  
**PAGE** 1 OF 1

<b>ORDER NO</b>	055535	<b>PO NO</b>	71993-D
<b>ITEM NO</b>	1	<b>PART NO</b>	
<b>ALLOY</b>	1100	<b>TEMPER</b>	O
<b>GAUGE</b>	06360	<b>WIDTH</b>	40.0000
		<b>FORM</b>	COIL
		<b>LENGTH</b>	.0000

**MILL FINISH**  
NON ANODIZE QUALITY  
OUT: STANDARD MILL FINISH  
IN: STANDARD MILL FINISH  
NOT EMBOSSED

**LOT:** 004297 **COIL:** B01

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
*B025571	0.12	0.47	0.13	0.003	0.008	0.000	0.003	0.002	0.01

HEAD ULTIMATE STRENGTH 13.8 KSI  
TAIL ULTIMATE STRENGTH 13.9 KSI  
HEAD YIELD STRENGTH 5.5 KSI  
TAIL YIELD STRENGTH 5.2 KSI  
HEAD ELONGATION 30.5 %  
TAIL ELONGATION 30.5 %

\* AS REPORTED BY SUPPLIER  
MECHANICAL PROPERTIES ACCORDING TO ASTM B557

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:  
QQA 250/1P 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL  
\*\* END OF CERTIFICATION \*\*

Date 12-11-98  
Cust. Ken-Mac Metals Inc.  
W/O # 483804  
Qty. 393 Pcs.  
These test reports are for material shipped  
on your PO# 2115  
From Copper & Brass Sales Inc.  
Jim Powers  
Quality Representative  
Customer Part # \_\_\_\_\_